



**UNITED STATES ENVIRONMENTAL PROTECTION AGENCY  
REGION 5  
77 WEST JACKSON BOULEVARD  
CHICAGO, ILLINOIS 60604**

**SUBJECT:** CLEAN AIR ACT INSPECTION REPORT  
Rahr Malting Company, Shakopee, Minnesota

**FROM:** Brianna Fenzl, Environmental Engineer  
AECAB (IL/IN)

**THRU:** Nathan Frank, Section Supervisor  
AECAB (IL/IN)

**TO:** File

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**BASIC INFORMATION**

**Facility Name:** Rahr Malting Company

**Facility Location:** 800 1st Ave W, Shakopee, Minnesota

**Date of Inspection:** July 12, 2022

**EPA Inspector(s):**

1. Brianna Fenzl, Environmental Engineer
2. Emma Leeds, Environmental Engineer

**Other Attendees:**

1. Mike York, Vice President of Operations, Rahr Malting Company
2. Eric Hansen, Director of Environmental Compliance, Rahr Malting Company

**Contact Email Address:** ehansen@rahr.com

**Purpose of Inspection:** To investigate compliance with the Clean Air Act

**Facility Type:** Malting facility

**Arrival Time:** 9:40 AM

**Departure Time:** 11:00 AM

**Inspection Type:**

☒ Unannounced Inspection

- ☐ Announced Inspection

### **OPENING CONFERENCE**

- ☒ Presented Credentials
- ☒ Stated authority and purpose of inspection
- ☐ Provided Small Business Resource Information Sheet
- ☒ Small Business Resource Information Sheet not provided. Reason: Not a Small Business
- ☒ Provided CBI warning to facility

The following information was obtained verbally from Rahr Malting Company (Rahr) unless otherwise noted.

### **Process Description:**

Raw barley is brought in by rail or truck and placed in bins to be cleaned. Once the barley is cleaned, it is allocated to clean barley bins. The cleaned barley is then taken to one of the six malthouses onsite. Within the malthouse, the barley goes through a three-step process. First, the barley is steeped for 48 hours. Then steeped barley is put in beds for germination. Barley germinates for four days. Finally, barley is transferred to one of eight kilns for drying for 24 hours. Building vents for germination vent directly to atmosphere. Heat recovery takes place at the kiln and then vents to atmosphere. A performance test was done on kiln vents in the 2000's for particulate and sulfur.

Rahr primarily produces "pale" malt and occasionally some darker malts.

There are 12 baghouses on site. Monitoring at the baghouses consists of daily visual emission inspections, differential pressure gauge readings, quarterly inspections, and annual differential pressure calibrations.

Rahr has a wastewater treatment plant onsite where liquid overflow from their process is sent.

### **Staff Interview:**

Rahr has been in operation since 1936 at this location. The facility operates 24/7 with 200 employees. Koda Energy, an energy company located on the same site that produces the propylene glycol used in the kilns, was acquired by Rahr approximately in late 2019 but currently operates under a separate permit. The throughput at the facility is 460,000 metric tons per year. Malthouse 6 was constructed and finished in 2017 to increase capacity by approximately 70,000 metric tons per year. Rahr mainly malts barley but also occasionally malts wheat and rye.

Hazardous air pollutants (HAPs) tracked by Rahr are related to natural gas consumption.

## **TOUR INFORMATION**

**EPA Tour of the Facility:** Yes

### **Data Collected and Observations:**

EPA inspectors toured Malthouse 6 and observed steep tanks, germination area, and kiln 8. Inspectors observed the heat recovery ducts and vents attached to the kiln.

**Photos and/or Videos:** were taken during the inspection.  
See Appendix A.

**Field Measurements:** were not taken during this inspection.

## **CLOSING CONFERENCE**

☒ Provided U.S. EPA point of contact to the facility

### **Requested documents:**

- Most recent semi-annual air emission report
- Past two annual air emissions reports
- Kiln performance test
- Most recent operating permit
- Koda Energy operating permit

## **DIGITAL SIGNATURES**

Report Author: \_\_\_\_\_

Section Supervisor: \_\_\_\_\_

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**APPENDICES AND ATTACHMENTS**

- 1.* Appendix A: Digital Image Log

**Facility Name:** Rahr Malting Company  
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**APPENDIX A: DIGITAL IMAGE LOG**

<b>1. Inspector Name:</b> Brianna Fenzl	<b>2. Archival Record Location:</b> Region 5 Electronic Records Center
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<b>Image Number</b>	<b>File Name</b>	<b>Date and Time* (incl. Time zone and DST)</b>	<b>Description of Image</b>
1	IMG_0112.JPG	7/12/22	Steep tanks
2	IMG_0113.JPG	7/12/22	Kiln 8

\*Photos taken between 10:30 AM and 11:00 AM CST.